

Work Order ID 132915

Friday, May 15, 2015 10:40:52 AM

132915

Page 1

Item ID: D4491-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge, Right Lower
 Start Date: 5/15/15 Start Qty: 2.00 *?
 Required Date: 5/21/15 Req'd Qty: 2.00 *?
 Reference: REWORK AS PER NCR15-4962 Cust Item ID:
 Customer:

Approvals: Process Plan: AA Date: 5-5-15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4491	A

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Quality Control

Memo

PULL FROM STOCK

D4491-4 X2

B: ~~79535~~ 79535 X 2

PART NOT IDENTIFIED

PREVIOUS BATCH: 79535

RE-IDENTIFY UNDER NEW BATCH AS PER DRWG.

200 Identify as per dwg & Stock Location: 5111 0.00

2000

Packaging

Packaging

Memo

0.00

DAS
38
9-89
MAY 19 2015

2 DAS
27
5-89

MAY 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MLJ MAY 21 2015

MLJ MAY 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Friday, May 15, 2015 10:40:58 AM

Page 1

Work Order ID: 132915

132915

Parent Item: D4491-4

D4491-4

Parent Item Name: Hinge, Right Lower

Start Date: 5/15/15

Required Date: 5/21/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4491-4		Manufactured	No				Each	1.0000		(2)			
D4491-4									**				
Hinge, Right Lower													

Location

ST111

89819

Loc Qty

1

1

Loc Code

79535 X2

(~~2~~) 5-5-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data ☐	Offset/Setup ☐																																																																						
Equip/Tooling ☐	Supplier ☐																																																																						
Handling/Pre ☐	Training ☐																																																																						
Material ☐	Use for Testing ☐																																																																						
Internal Transport ☐	Poor Information ☐																																																																						
Tribal Knowledge ☐	Rushing ☐																																																																						
LOA ☐	Product Improvement ☐																																																																						
Substation ☐	Process Improvement ☐																																																																						
Past Expiry Date ☐	Manufacturing Process ☐																																																																						
Misidentified ☐	Past Due ☐																																																																						
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER :																																																																							

Closed by Eric Dec 8/15



Non-Conformance Report

Reviewed			
DQA:			
Date:			
Printed on: Friday, May 15, 2015			
Details			
Raised Date 5/15/2015	Status Open	Owner Forbes, Nigel	Number NCR15-4962
Target Date 6/2/2015	Standard	Severity MAJOR	
Process Employee finding		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Manufacturing\Receiving/Stores/Packaging		Fault Category General\Label/Identification
Details found in stores department parts with out batch numbers. D4491-2 qty x3 parts found, D4491-4 qty x2 parts found and qty x1 D4577-1 found with no batch numbers			
Keywords incorrct identified parts		Product	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 6/1/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
4	Poulin, Mario	5/22/2015	
issue2 1-work order that contains all batches of D4491-4 to re-inspect non identified parts to current drawings1-work order that contains all batches of D4491-2 to re-inspect non identified parts to current drawings		D4491-4 x 2 -> w/o 132915 D4491-2 x 3	
1	Downing, Eric M	5/15/2015	5/15/2015
try to track down batch numbers for D4491-2 & D4491-4		unable to track down batch numbers	
2	Downing, Eric M	5/15/2015	5/15/2015
scrap D4577-1 panel		panel scraped	

3	Forbes, Nigel	5/29/2015	
investigate reason why parts in store have no batch numbers / tags attached to them			

Verification & Review

Target Date 6/1/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	